



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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SWA3-100
Job Sheet 192201



Part No: SWA3-100

Job Qty: 10 pcs

Part Name: Upper End - Swa3 Swivel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/19/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA3-100 Rev 15 IPP Rev A 18.02.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs	5/3/19	5/3/19	0.00	1.00	Bandsaw - 1		
110	NLX 2500SY - B4B	10 pcs	5/3/19	5/3/19	0.00	10.00	NLX 2500SY - 1 - B4B		
120	QC 2	10 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



Container No: S174084



Part: SWA3-100

Job No: 192201

Serial No/Batch: S174084

Revision: 15

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/22/19

Plex 3/19/19 10:54 AM Dart.lajeunesse.marie

130 QC 8	10 pcs	5/3/19	0.00	0.00	QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 8 - 12	
					QC 8 - 14	mL19/05/03
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
140 Packaging 3-1 - Stock - B4B	10 pcs	5/3/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS
					Packaging 3 - 8 - B4B	30
					Packaging 3 - 9 - B4B	9-69
					Packaging 3 - 10 - B4B	MAY 06 2019
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	10 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS MAY 06 2019
				QC 21 - SA - 53	21
Part Op 100 - (Bandsaw) Cut Blanks to 6.250"					
Descriptions: 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per DWG. FC330 FOLIO REV: <u>AA</u> DWG REV: <u>15</u>					
2-Deburr ***Machine engrave S/N number and machine engrave UP arrow***					
120 - (QC2- Inspect parts off machine FAI/FAIB)					
130 - (QC8- Inspect parts - second check)					
140 - (Identify as per dwg & Stock Location <u>GA 182</u>)					
150 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M17-4-H1150-R2.000	17-4 SS Round Bar 2.000"	5.2000 ft (.52 ea)	100-Bandsaw - 1	<u>5173786</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M17-4-H1150-R2.000	5	3	0	
Part Specifications					
Specifications could not be found.					

MAT
used
120

Plex 3/19/19 10:54 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



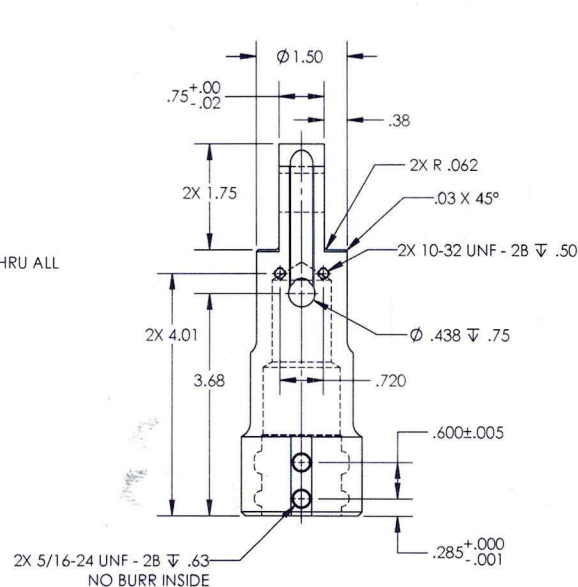
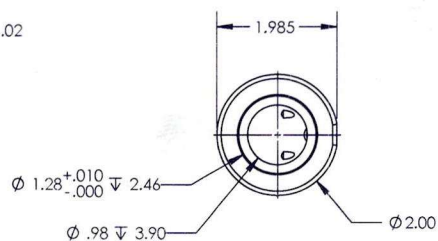
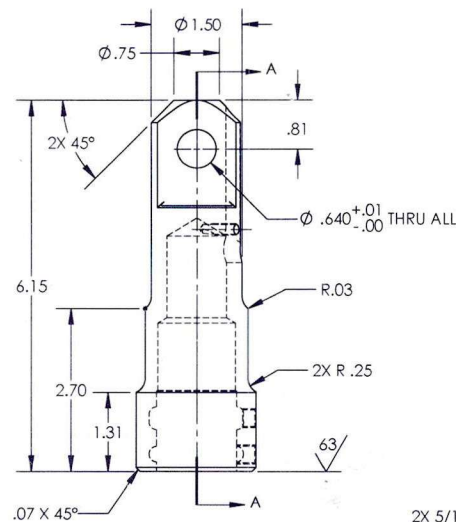
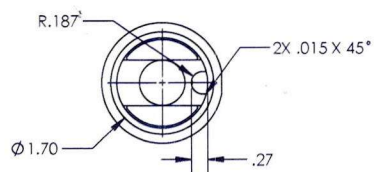
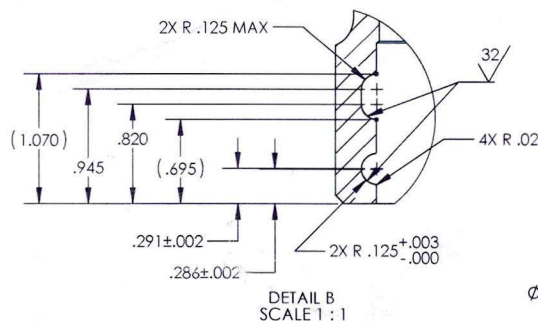
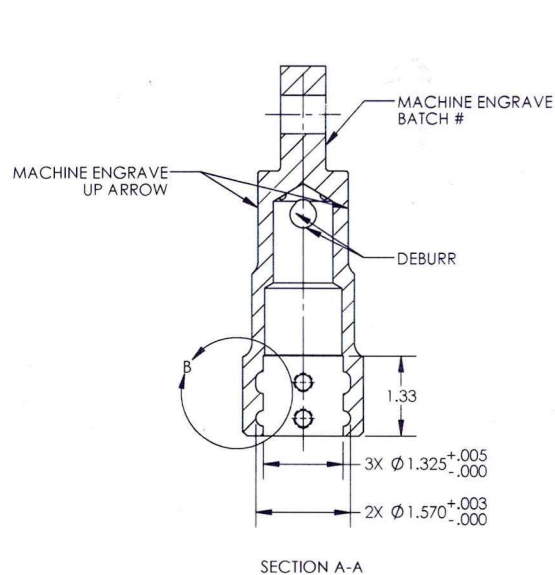
WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192201 MWS
19-03-19

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
11		AS DRAWN BY CANAM	8/24/2012	
11A		CHD DIMENSIONS 1.070 & .695 TO REFERENCE. ADDED CENTER DIMENSIONS OF .945 & .820	11/15/2012	JAG
12	15-0270	ADDED UP ARROW NOTE. CHD MAT'L WAS S.S. 17-4 PH IS S.S. 17-4. H1150/1075. CHD DIM WAS .75 IS .75 ± .001 ± .02.	9/22/2015	DPD
13	16-0083	CHD DIM WAS .375 IS .38. WAS .286 IS .286 ± .002. WAS .291 IS .291 ± .002. WAS Ø 1.325 ± .005/-0.000 IS 3X Ø 1.325 ± .005/-0.000. WAS Ø 1.570 ± .003/-0.000 IS 2X Ø 1.570 ± .003/-0.000.	7/18/2016	SM
14	17-0036	CHD DIMS WAS 1.75 IS 2X 1.75. WAS 2X 5/16-24 UNF - 2B ± .625 NO BURR INSIDE IS 2X 5/16-24 UNF - 2B ± .63 NO BURR INSIDE. WAS 4X R.015 IS 4X .02. ADDED NOTE MACHINE ENGRAVE BATCH #.	2/6/2017	RJC
15	17-0153	CHD DIM WAS Ø 1.00 ± .010/-0.000 ± 3.90 IS Ø .98 ± 3.90.	6/20/2017	RJC

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA3-100	1	UPPER END	S.S. 17-4, H1150/H1075	

DART AEROSPACE	
TITLE: UPPER END SWA3 SWIVEL	
DWG NO. SWA3-100	REV 15
MAT'L S.S. 17-4, H1150/H1075 FINISH .XXX ± .005 FRACTIONS ± 1/8 SPEC. 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CANAM CHECKED: DUERFELDT APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
SCALE 1:2	DATE 6/18/2002 SHEET 1 OF 1

DART AEROSPACE LTD		Work Order: 192201
Description: upper end SWA3 Swivel		Part Number: SWA3-100
Inspection Dwg: SWA3-100	Rev: 15	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.33	$\pm .01$	1.325			Vern LPI0	
Ø 1.325	$\pm .005 / - .000$	1.327			Mic LPO5	
Ø 1.570	$\pm .003 / - .000$	1.572			112-177	
R.187	$\pm .005$	.187			Rad gauge	
.015 x 45°	$\pm .005 \times .5^\circ$	.015 x 45°			Vern LPO	
.27	$\pm .01$	.271			H-gauge	
Ø 1.70	$\pm .01$	1.698			Vern LPI0	
Ø 1.50	$\pm .01$	1.498			↓	
Ø .75	$\pm .01$	.75			↓	
45°	$\pm .5^\circ$	45°			Protractor	
6.15	$\pm .01$	6.145			Vern LPI0	
2.70	$\pm .01$	2.70			↓	
1.31	$\pm .01$	1.31			↓	
R.25	$\pm .01$	.25			Rad gauge	
R.03	$\pm .01$	.032			↓	
Ø .640	$\pm .01 / - .000$	.642			Gauge Pin	
.81	$\pm .01$	.810			Mic LPO6	
1.985	$\pm .005$	1.9825			Mic LPO2	
1.28	$\pm .01 / - .00$	1.285			Vern LPI0	
Ø .98	$\pm .01$	.990			↓	
2.46	$\pm .01$	2.453			↓	
3.90	$\pm .01$	3.910			↓	
Ø 2.00	$\pm .01$	1.994			Mic LPO2	
Ø 1.50	$\pm .01$	1.498			Vern LPI0	
.75	$\pm .00 / - .02$	.738			↓	
1.75	$\pm .01$	1.750			↓	
4.01	$\pm .01$	4.005			H-gauge	
3.68	$\pm .01$	3.670			↓	
.285	$\pm .000 / .001$	.286			Mic LPO6	

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 19-04-26	Date: 19/05/03	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

